

Date: Monday, 16/06/2008 10:25:26 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE		
Job Number	: 39887		Part Number	: D29321		
Estimate Number	: 10831		Drawing Number	: D2932 REV C		
P.O. Number	:		Project Number	: N/A		
This Issue	: 16/06/2008		Drawing Revision	: C		
Prsh Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 04/07/2008		
Previous Run	: 34783		Qty:	6 Um: Each		
Written By	:					
Checked & Approved By	: <u>Jul 08. le. 15</u>					
Comment	: Est: B 00.06.26 New DWG rev, (mpp 2069) EC					
	Est Rev:C As per Rev C 07-03-19 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	Saddle Billet, 7075	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length Batch No: <u>B33792</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr & TUMBLE	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

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Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
7.0	POWDER COATING	POWDER COATING m107925
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
9.0	PACKAGING 1	PACKAGING RESOURCE #1
10.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: SECOND CHECK *mf 08/06/27 (1)*

Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1 *bk / QD 08/07/01 (6)*

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
START TIME: *7:40*
OVEN TEMPERATURE: *320*
FINISH TIME: *8:00* *bk / QD 08/07/02*

Comment: INSPECT POWDER COAT *S 08/07/02 (46)*

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *428* *8/7/2* *SP* *08/07/03 (8)*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

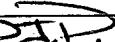
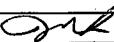
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD			Work Order:	39887
Description: 206 Saddle, Outboard, Left side			Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.125	0.123	0.125	0.124		
B	0.100	0.140		0.125	0.123	0.122	0.126		
C	0.100	0.140		0.120	0.125	0.127	0.136		
D	0.210	0.230		0.220	0.218	0.218	0.218		
E	1.245	1.255		1.248	1.249	1.250	1.250		
F	1.245	1.255		1.249	1.249	1.249	1.250		
G	2.495	2.505		2.500	2.500	2.501	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.575	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.260	0.260	0.260	0.260		
L	0.312	0.317		0.316	0.316	0.315	0.316		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.120	0.118	0.118	0.118		
O	0.540	0.560		0.541	0.549	0.550	0.551		
P	0.490	0.510		0.499	0.494	0.490	0.495		
Q	3.715	3.725		3.718	3.718	3.717	3.719		
R	2.470	2.510		2.497	2.497	2.497	2.497		
S	0.240	0.270		0.2475	0.250	0.247	0.2485		
T	0.100	0.180		0.135	0.135	0.135	0.140		
U	1.625	1.635		1.628	1.630	1.630	1.630		
V	1.362	1.372		1.365	1.367	1.367	1.367		
W	0.316	0.321		0.321	0.321	0.321	0.321		
X	1.125	1.145		1.1345	1.134	1.1325	1.1335		
Y	1.565	1.585		1.5745	1.574	1.5725	1.5725		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA	-								
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:		Audited by:	
Date:	08/06/26	Date:	08/06/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM 	

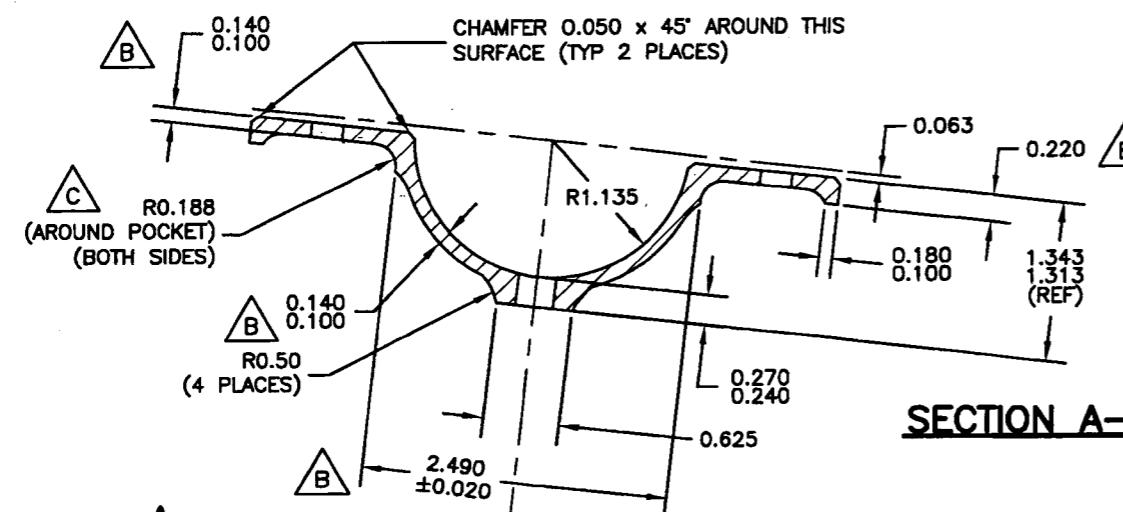
DART AEROSPACE LTD		Work Order:	39887
Description: 206 Saddle, Outboard, Left side		Part Number:	D2932-1
Inspection Dwg:	D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

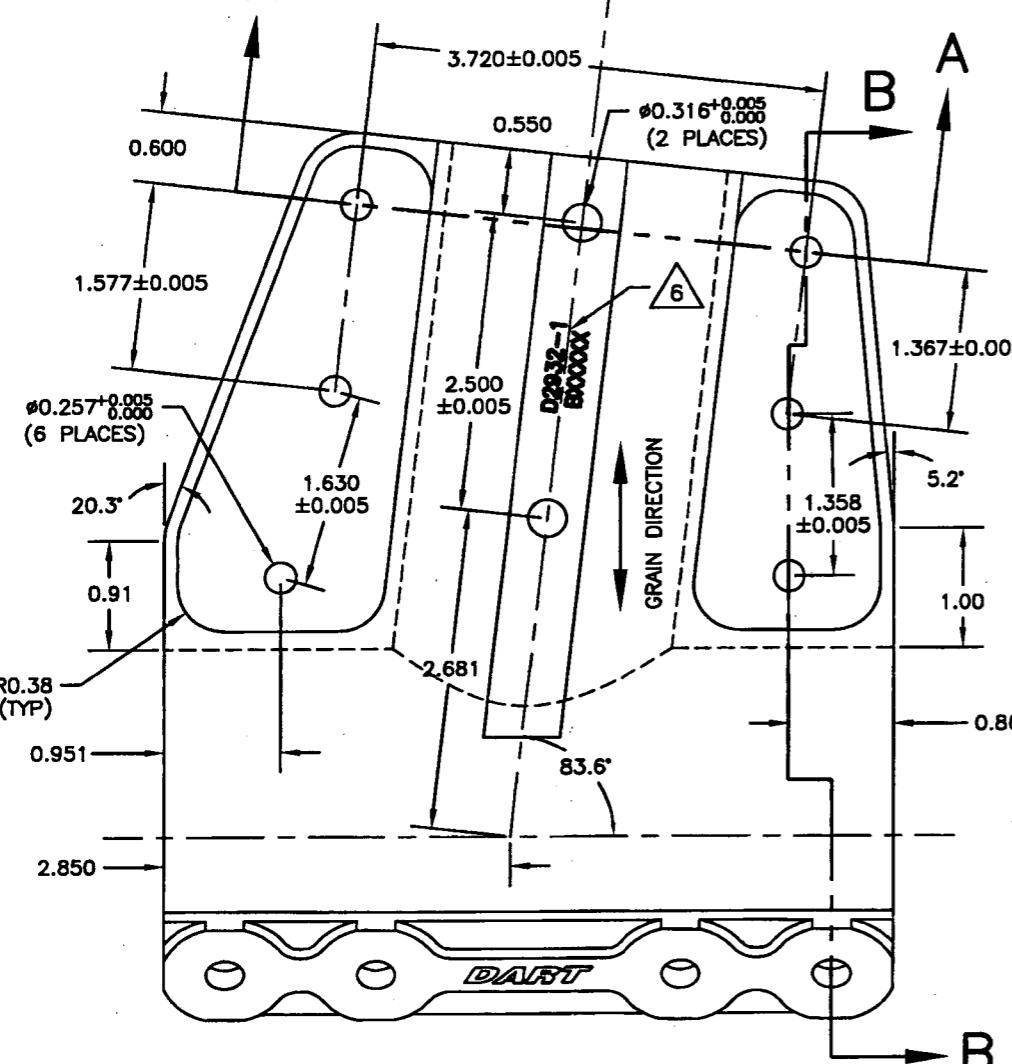
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	3	4	By	Date
A	0.100	0.140		0.124	0.125				
B	0.100	0.140		0.123	0.125				
C	0.100	0.140		0.130	0.130				
D	0.210	0.230		0.217	0.217				
E	1.245	1.255		1.250	1.2485				
F	1.245	1.255		1.250	1.249				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		0.511	0.511				
I	1.572	1.582		1.576	1.575				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		0.260	0.260				
L	0.312	0.317		0.316	0.316				
M	0.235	0.240		0.238	0.238				
N	0.100	0.140		0.118	0.118				
O	0.540	0.560		0.5515	0.551				
P	0.490	0.510		0.500	0.496				
Q	3.715	3.725		3.720	3.719				
R	2.470	2.510		2.497	2.498				
S	0.240	0.270		0.248	0.248				
T	0.100	0.180		0.140	0.140				
U	1.625	1.635		1.630	1.629				
V	1.362	1.372		1.366	0.136065				
W	0.316	0.321		0.321	0.321				
X	1.125	1.145		1.133	1.134				
Y	1.565	1.585		1.5725	1.5735				
Z	0.178	0.198		0.188	0.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	DT	Audited by:	TM
Date:	08/06/27	Date:	08/06/27

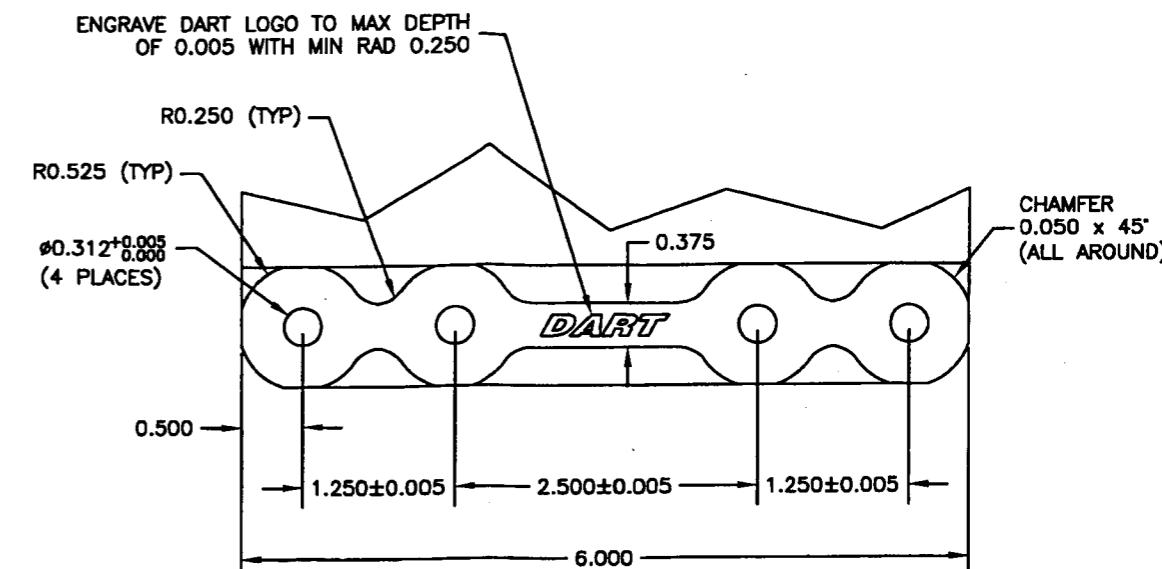
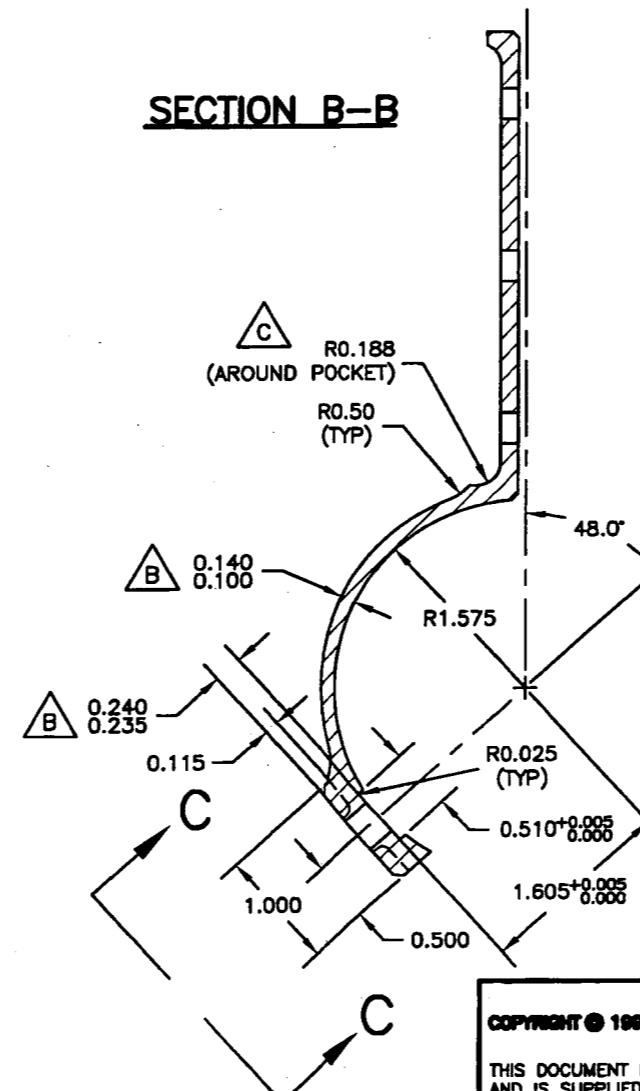
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	TM



SECTION A-A



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31887

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE

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DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	DART	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED		DRAWING NO.
PH	CB		D2932
DATE	TITLE	SCALE	REV. C SHEET 1 OF 1 2:3
06.11.09	SADDLE OUTSIDE		